

Date: Monday, 12/05/2008 1:56:32 PM
 User: Julie Lecocq

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : COBRA SKIDTUBE ASS'Y
 Job Number : 39204A
 Estimate Number : 13181
 P.O. Number :
 This Issue : 12/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SKIDTUBES
 Previous Run : 37407A
 Part Number : D209669043
 Drawing Number : D2906 REV.B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 23/05/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 08.5.12
 Comment : new est. 08.02.13 LL, verified by: DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D209-669 bluefile & type labels per PPP D205-669-041 chg 002

N/A

2.0 D25001190 Ext'n -I' Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B375C14

①

W 8-5-13

3.0 D29263 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

batch 39225

SL 8-5-13

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2906 if necessary Deburr ends

3-Acid etch and Alodine tube per QSI 005 4.1

W 8-5-13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Job Number: 39204A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RT 08-05-13

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2906 without cutting fluid

3-Countersink holes as per Dwg D2906 without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------|-------------|-------|
| A/R | Sikaflex-291 | 107804 | |

Sikaflex expire date: 8-7-31

Start Time: 3:00 Date: 8-5-13

Fin Time: 3:00am Date: 8-5-14

pick:

| Qty | P/N | description | B/N |
|-----|---------|-------------|-------|
| 1 | D2926-3 | Web | 39225 |

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program COB41FWD & COBRAFT on CNC Bender and Folio FT

2-Cut tubes as per Dwg. D2906 & per template DT8185B & DT8185BC

EL/RT 8-5-14

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

RT 08-05-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Drawing Name: COBRA SKIDTUBE ASSY

Job Number: 39204A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/14 @

10.0

D2579

Crossbolt Spacer



Comment: Qty.: 19.0000 Each(s)/Unit Total: 19.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 19 | D2579 | Spacers | 238393 |

BE 08/05/15

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld crossbolt spacers D2579 as per Dwg. D2906 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill.

A/R Aluminum Rod

m107263 BE 08/05/15

2-Grind welds as per Dwg D2906 Grind flush ridge made from bending

3-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

4-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2906, Deburr holes

5-Drill pilot holes for aft & fwd cap using DT8025 open holes to #6" Deburr

6-Drill pilot holes for Tow ring using DT8091-3 open to .640" and Deburr

SL 8-5-15

12.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/05/15 @

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/15 @

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Job Number: 39204A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005.

08-05-15

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M1107925

(X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:03
320°F
8:33

M-1 08/05/16

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-20

(X)

17.0

D2855

Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cap

Batch:

1338395

YJ

18.0

AN35A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M1100188

YJ

19.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch:

M104885

YJ

20.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Insert

OR PER QSI 017

Batch:

M105819

YJ

08-05-20

(X)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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Drawing Name: COBRA SKIDTUBE ASS'Y

Job Number: 39204A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN3C4A

BOLT



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

BOLT

Batch: 11107737

91

22.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

Batch: 26 batches (4x) => M107939

35x1 => M107939

Batch: 26 batches (4x) => M107971

91

23.0

D25943

O-Ring, 205 Skidtube



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

O-Ring

Batch: 1329908

91

24.0

D25941

Plug, 205 Skidtube



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Plug

Batch: 1337419

91

25.0

D35649

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

batch 1338408

91

26.0

D356411

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

batch 1338548

91

27.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

batch 1338409

91

08-05-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Job Number: 39204A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

batch

B39236

92

29.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

batch

B39247

AD

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates

✓ A/R Sikaflex-291 M107804
Sikaflex expire date: 08/10

✓ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

✓ 3-Inspect for foreign object per QSI 024

✓ 4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M107804
Sikaflex expire date: 08/10

✓ 5-Wing Walk as per Dwg D2906 and QSI 005 4.4

Batch: M107892

92 08-05-20

41

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D209-669-041

Location:

PPP Rev:

PPD 35204

08-05-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 39204A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/23 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-05-22

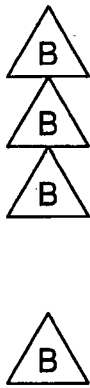
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NOTE: Date & initial all entries



| QTY -041 | QTY -043 | Part Number | Description |
|-------------|-------------|---|-----------------------------|
| X | | D2906-041 | SKIDTUBE ASSEMBLY |
| | X | D2906-043 | SKIDTUBE ASSEMBLY |
| 1 | 1 | D2500-1-190 | EXTRUSION |
| 22 | 19 | D2579 | CROSS BOLT SPACER |
| 12 | 14 | D2594-1 | PLUG |
| 12 | 14 | D2594-3 | O-RING |
| 2 | 2 | D2855 | AFT CAP |
| 1 | | D2926-1 | WEB |
| | 1 | D2926-3 | WEB |
| 1 | 1 | D3564-9 | WEARSHOE (REPLACES D2577-1) |
| 1 | 1 | D3564-11 | WEARSHOE (REPLACES D2577-3) |
| 1 | 1 | D3564-5 | WEARSHOE (REPLACES D2577-5) |
| 1 | | D3564-15 | WEARSHOE |
| 2 | 2 | D3566-1 | GASKET |
| 1 | 1 | D3566-5 | GASKET |
| 1 | | D3566-15 | GASKET |
| 50 | 44 | ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130 | INSERT |
| 50 | 44 | AN3C4A | BOLT |
| 4 | 4 | AN3-5A | BOLT |
| 50 | 44 | AN960C10L | WASHER |
| 4 | 4 | AN960JD10L | WASHER |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

SHOP COPY

RETURN TO

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UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

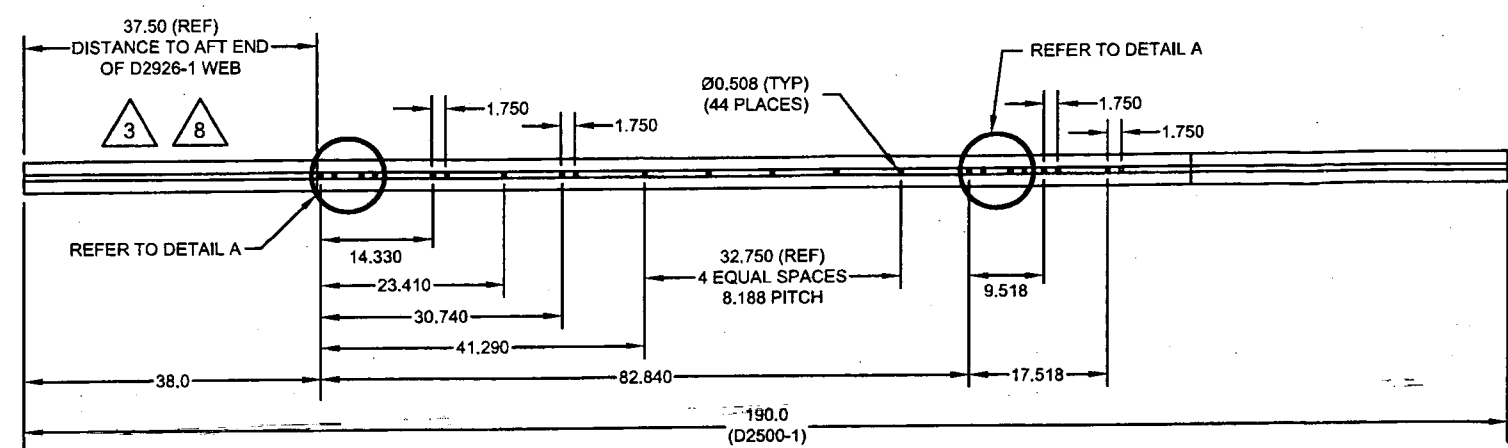
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RELEASED

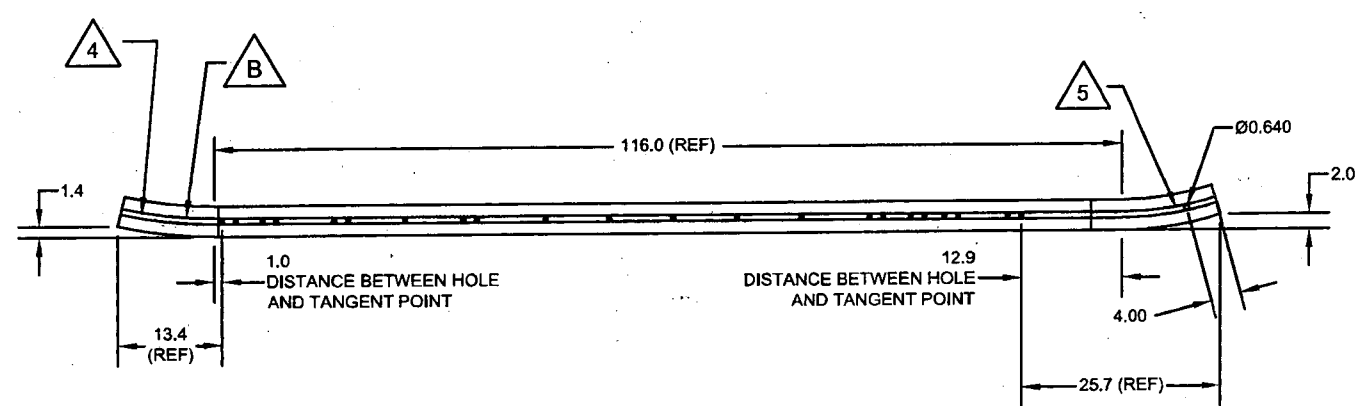
07.09.04

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|------------|--|--|--------------|
| B | UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES; | CB | 07.08.21 |
| A | NEW ISSUE | CP | 04.06.22 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | qp | DART AEROSPACE LTD | |
| DRAWN | CB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PH | DRAWING NO. | REV. B |
| MFG. APPR. | PH | D2906 | SHEET 1 OF 3 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | AH-1 (209) SKIDTUBE ASSEMBLY | NTS |
| DATE | 07.08.21 | COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

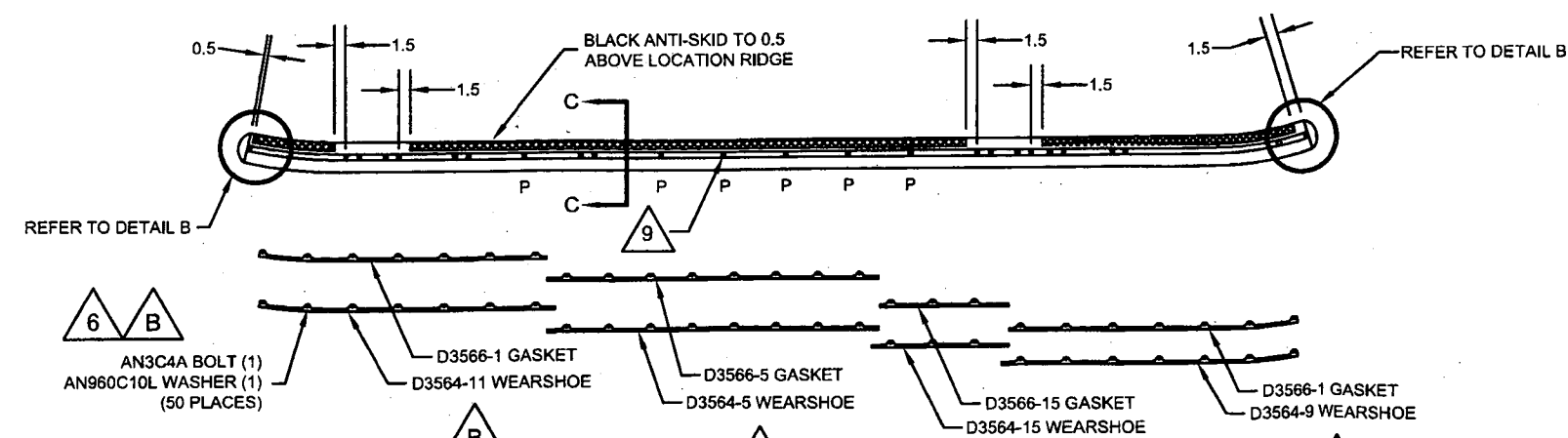
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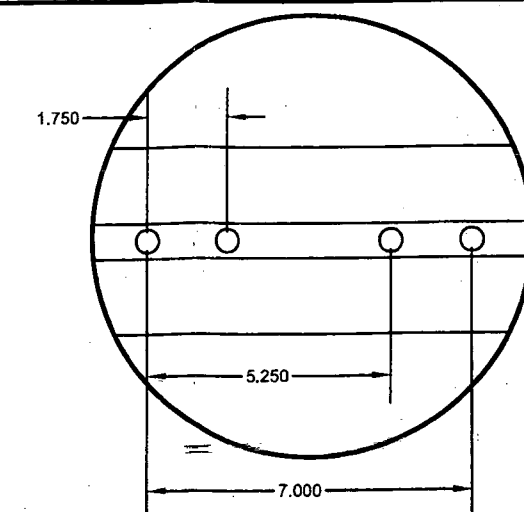
D2906-1 DRILLING DETAIL



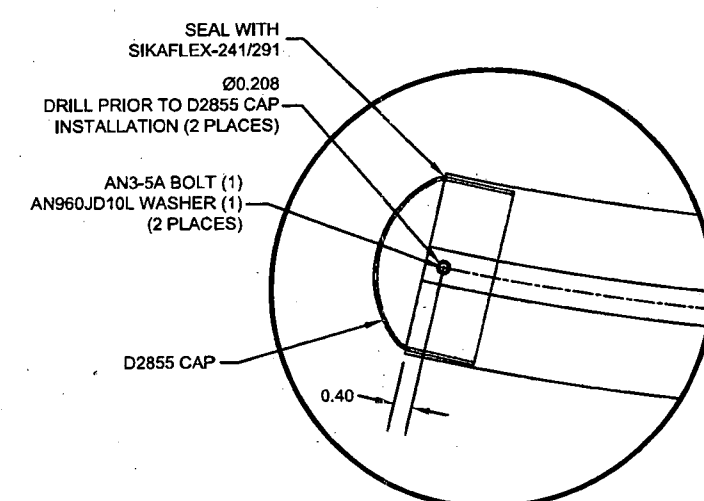
D2906-041 BENDING AND CUTTING DETAIL



D2906-041 ASSEMBLY DETAIL



**DETAIL A
SCALE 1:4**

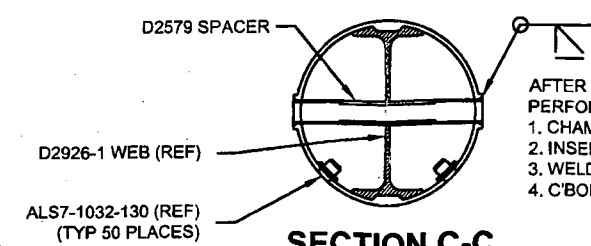


**DETAIL B
SCALE 1:4**

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WORK ORDER
NO. 392047

RELEASED

07.09.04



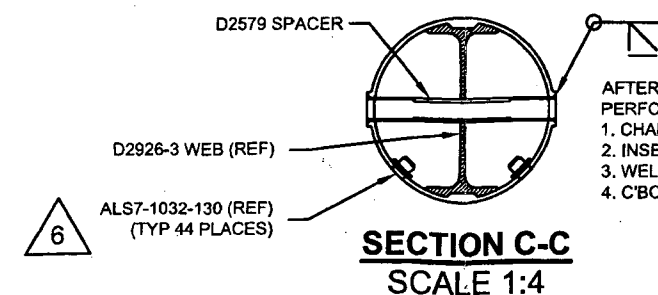
**SECTION C-C
SCALE 1:4**

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (22 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

| | | | |
|------------|----------|--|--------------|
| DESIGN | 97 | DART AEROSPACE LTD | |
| DRAWN | CB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PH | DRAWING NO. | REV. B |
| MFG. APPR. | PH | D2906 | SHEET 2 OF 3 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | AH-1 (209) SKIDTUBE ASSEMBLY | 1:24 |
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RELEASED
07-09-04



| | | | |
|------------|----------|--|--------------|
| DESIGN | 90 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CB | | |
| CHECKED | PH | DRAWING NO. | REV. B |
| MFG. APPR. | 21 | D2906 | SHEET 3 OF 3 |
| APPROVED | 10 | TITLE | SCALE |
| DE APPR. | 11 | AH-1 (209) SKIDTUBE ASSEMBLY 1:24 | |
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NO. 154

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 32940 A
Part number: D205 624 041
Description: Skid tube 205
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass ☒ fail ☐
pass ☐ fail ☐

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐

Qualifier Del Duval Date of Test Coupon 0805-07

Welder Barclay Elliot Date of Test Coupon 08-05-07

The above named individual is qualified in accordance with AWS D17.1.2001 to weld